

Work Order ID 83779

April-25-12 12:41:11 PM

SHIP 26/04

\*83779\*

Page 1

Item ID: D4108-047

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Sill Doubler Assembly

Start Date: 4/25/12 Start Qty: 1.00

\*1\*


Cust Item ID:

Required Date: 4/26/12 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:   
QC:

Date:

Tooling:

Date:

Run Start \*NR1\*

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr	Revision Nbr
D4108	B

110 0.00

\*110\*


Small Fab

Memo

0.00

Small Fab

1- ASSEMBLE AS PER DWG

1X  

120 QC5- Inspect part completeness to step on W/O 0.00

\*120\*

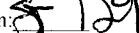
QC

Memo

0.00

Quality Control

130 Identify as per dwg & Stock Location:  0.00


\*130\*

Packaging

Memo

0.00

Packaging

1X  12-04-26

**Work Order ID 83779**

April-25-12 12:41:11 PM

**\*83779\***

Page 2

Item ID: D4108-047

Revision ID:

Item Name: Sill Doubler Assembly

Start Date: 4/25/12 Start Qty: 1.00

Required Date: 4/26/12 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

12/4/26 J

mf  
12-04-26

# Picklist Print

April-25-12 12:41:11 PM

Page 1  
*[Signature]*

Work Order ID: 83779

Parent Item: D4108-047

Parent Item Name: Sill Doubler Assembly

Start Date: 4/25/12

Required Date: 4/26/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD IPP Rev:B 10.12.03 as per dwg  
rev.B DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3622-1 Ball Stud		Manufactured	No			110	Each	21.0000	1	1		4/25/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST058		21							
				78837		1							
				80405		20			1				
NAS1149C0532R WASHER		Purchased	No			110	Each	369.0000	2	2		4/25/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST297		369							
				116373		1							
				116513		53							
				119736		315			2				
MS21043-5 Nut		Purchased	No			110	Each	638.0000	1	1		4/25/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		20							
				101418		20							
				ST300		4							
				112314		4							
				ST301		614							
				116548		100							
				118159		89			1				
				119307		25							
				119537		200							
				121283		200							

# Picklist Print

April-25-12 12:41:11 PM

Page 2

Work Order ID: 83779

Parent Item: D4108-047

Parent Item Name: Sill Doubler Assembly

Start Date: 4/25/12

Required Date: 4/26/12

Start Qty: 1.00

Required Qty: 1.00

D4108-7  
Bracket

Manufactured No

110 Each 7.0000 1 1

Location

Loc Qty

Loc Code

st128

7

76483

7

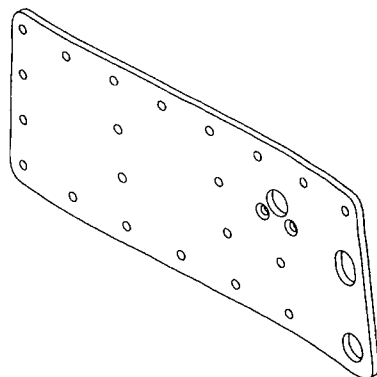
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*LB 12/04/20*

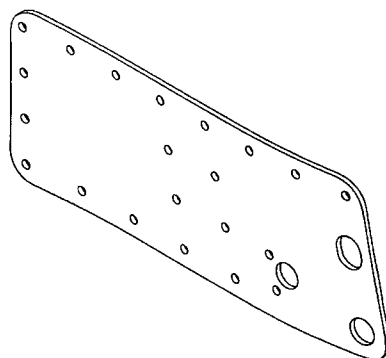
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Shop Packet Print

Page 2



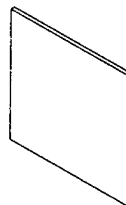
**D4108-1 LEFT PASS DOOR DOUBLER**



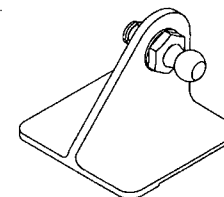
**D4108-3 RIGHT PASS DOOR DOUBLER**



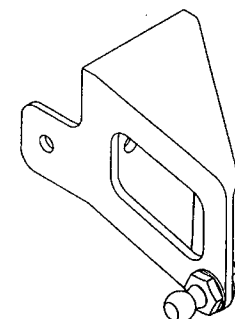
**D4108-5 SMALL RIGHT DOOR DOUBLER**



**D4108-11 TEMPLATE**



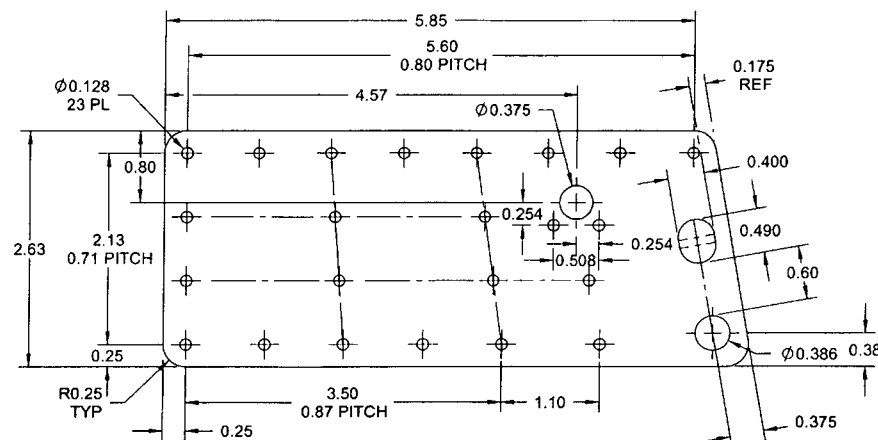
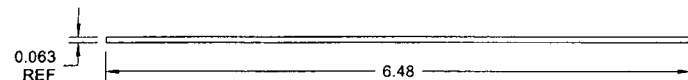
**D4108-047 SILL BRACKET ASSEMBLY**



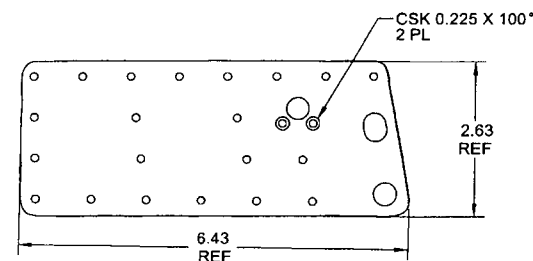
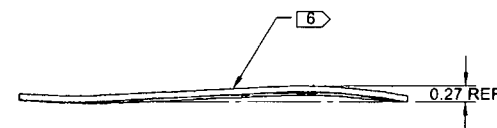
**D4108-049 LITTER DOOR FITTING ASSEMBLY**

**RELEASED**  
2010-11-30

B	D4108-5 (ZN C4-1 & B4-4) VIEWS UPDATED. D4108-7/-9 MTL CHANGED TO 6061-T6 AL. NOTES UPDATED (SHT 5,8)	JPH	10.11.01
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4108	SHEET 1 OF 7
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLERS & FITTINGS	NTS
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**D4108-1F FLAT PATTERN, LEFT PASSENGER DOOR DOUBLER**



**D4108-1 LEFT PASS DOOR DOUBLER (MAKE FROM D4108-1F)**

**NOTES:**

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-1: MAKE FROM D4108-1F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -1: P/N D4108-1 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.29 lbs
- 8) FORM & INSPECTION PER TEMPLATE DT9648.

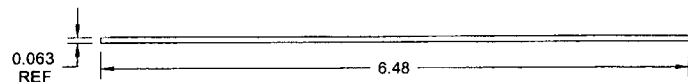
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2010-11-30  
WP

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO. <b>D4108</b>	REV. B
MFG. APPR.		SHEET 2 OF 7	
APPROVED		TITLE	SCALE
DE APPR.		<b>DOUBLERS &amp; FITTINGS</b>	NTS
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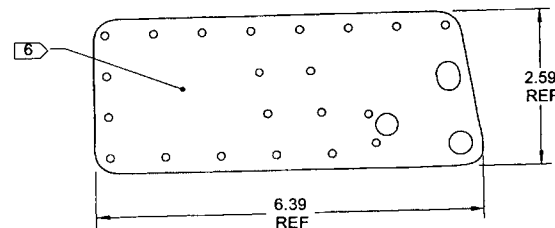
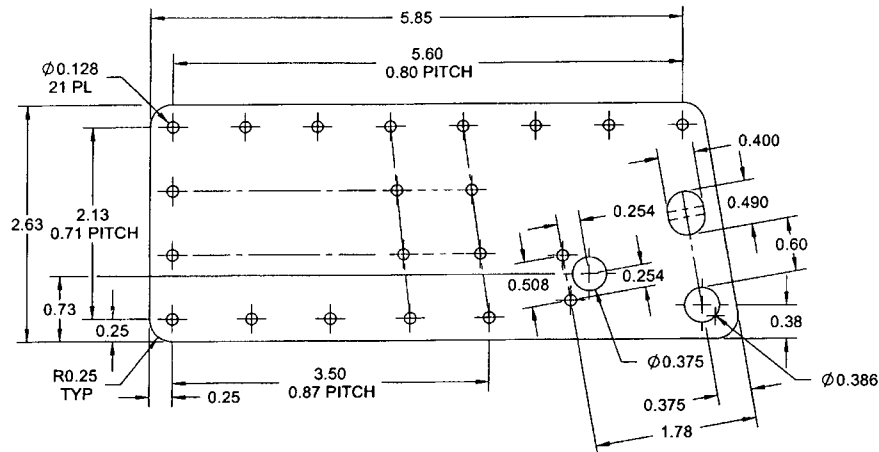
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**D4108-3 RIGHT PASS DOOR DOUBLER** 8  
(MAKE FROM D4108-3F)

**D4108-3F FLAT PATTERN, RIGHT PASSENGER DOOR DOUBLER**

**NOTES:**

- 1) MATERIAL -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-3: MAKE FROM D4108-3F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -3: P/N D4108-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.29 lbs
- 8) FORM & INSPECTION PER TEMPLATE DT9649.

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2010-11-30  
W

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
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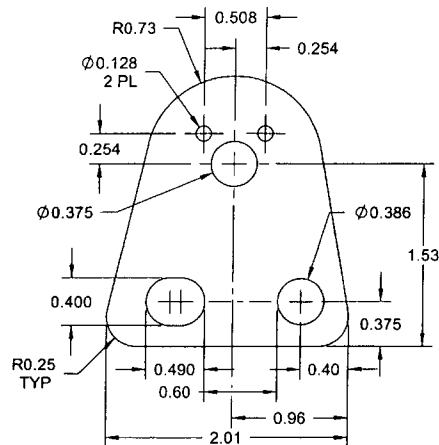
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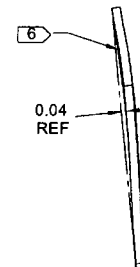
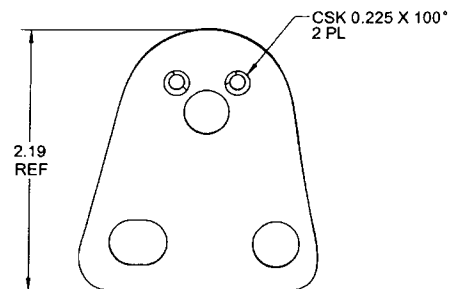
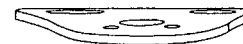
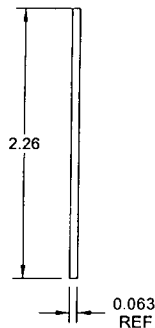
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**D4108-5F FLAT PATTERN, SMALL RIGHT DOOR DOUBLER**



**D4108-5 SMALL RIGHT DOOR DOUBLER (MAKE FROM D4108-5F)**

**NOTES:**

- 1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-5: MAKE FROM D4108-5F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -5: P/N D4108-5 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9649.

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2010-11-30  
JN

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO. <b>D4108</b>	REV. B
MFG. APPR.	JPH	SHEET 4 OF 7	
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	<b>DOUBLERS &amp; FITTINGS</b>	NTS
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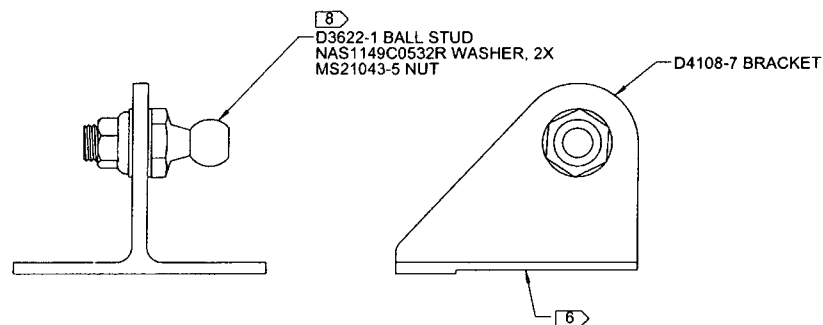
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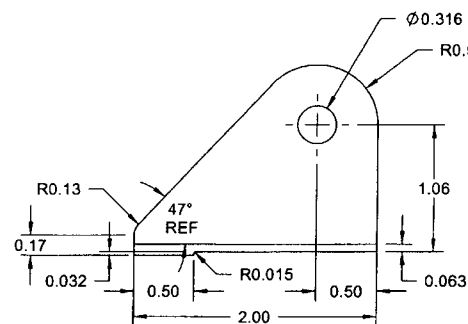
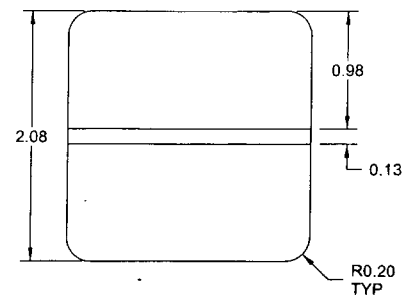
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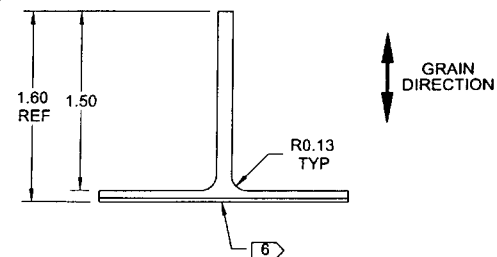
Qty -047	Part Number	Description
1	D4108-047	SILL BRACKET ASSEMBLY
1	D4108-7	BRACKET
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



**D4108-047 SILL BRACKET ASSEMBLY**



**D4108-7 BRACKET**



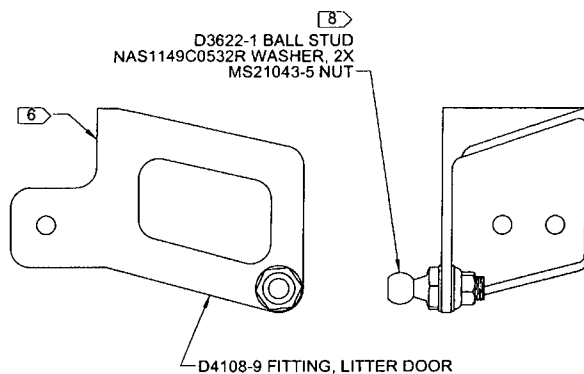
**NOTES:**

- 1) MATERIAL -7: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
- 7) WEIGHT -047: 0.10 lbs
- 8) TORQUE TO 5-10 INCH POUND.

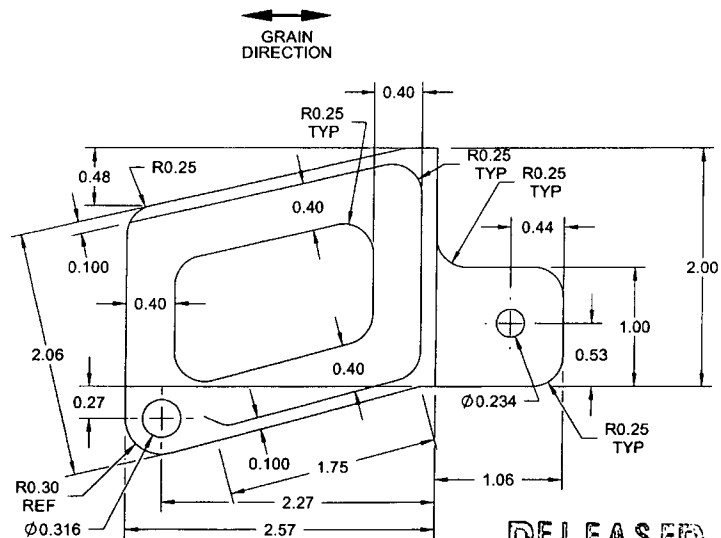
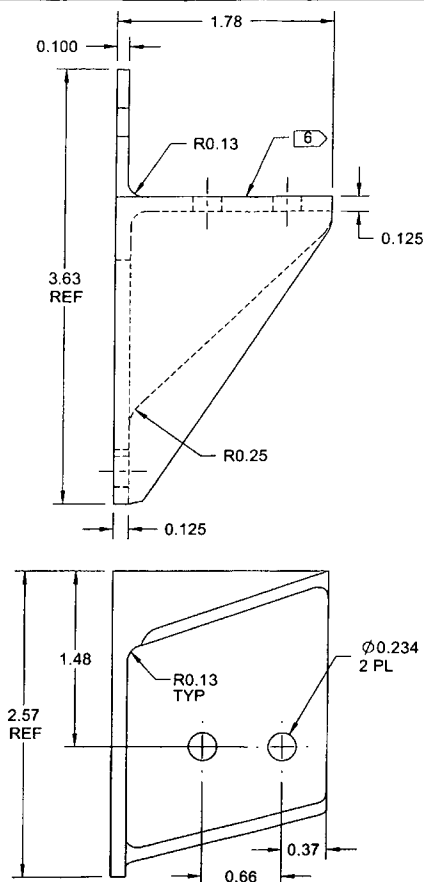
DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	<b>D4108</b>	SHEET 5 OF 7
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	<b>DOUBLERS &amp; FITTINGS</b>	NTS
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2010-11-30  
AM

Qty	Part Number	Description
-049	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



**D4108-049 LITTER DOOR FITTING ASSEMBLY**



**D4108-9 FITTING, LITTER DOOR**

- NOTES:**
- MATERIAL -9: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - UNITS: INCHES UNLESS OTHERWISE NOTED.
  - BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
  - WEIGHT -049: 0.19 lbs
  - TORQUE TO 15 INCH POUND.

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. B
CHECKED		<b>D4108</b>	SHEET 6 OF 7
MFG. APPR.		TITLE	SCALE
APPROVED		<b>DOUBLERS &amp; FITTINGS</b>	NTS
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DATE	10.11.01		

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R 2010-11-30

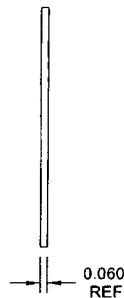
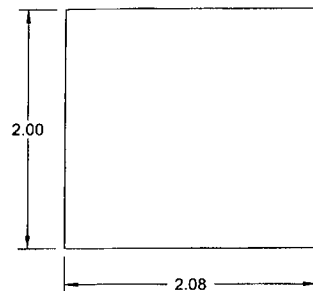
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# **D4108-11 TEMPLATE**

RELEASED  
2010-11-30  
N8

## **NOTES:**

- 1) MATERIAL: LEXAN 9034 SHEET, 0.060 THK  
REF DART MLEXS.060-9034-08  
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.  
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N D4108-11 PER QSI 044 6.1
- 7) WEIGHT: N/A

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4108</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE <b>DOUBLERS &amp; FITTINGS</b>	SHEET 7 OF 7 SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.11.01		

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